

114772



SIBLEY MACHINE AND FOUNDRY CORPORATION

206 E. TUTT STREET / P.O. BOX 40 / SOUTH BEND, IN. 46624 / (219) 288 - 4811

January 21, 1982

Wayne Reclamation & Recycling, Inc.
P. O. Box 467 - Daniel Drive
Columbia City, IN 46725

Attention: Mr. Larry C. Brockman

Larry,

Enclosed are the two (2) chemical analysis reports of our non-toxic water solubles that you haul away.

If any additional information is required, please feel free to call.

Thank You.

Sincerely,

SIBLEY MACHINE & FOUNDRY CORPORATION

Don Plummer
Maintenance Supervisor,
Machine Division

DP/cmb
Enclosures

CIMCOOL S2

RECOMMENDED STARTING DILUTIONS

Operation	Carbon Steels	Steel Alloys	Copper Alloys	Aluminum	Glass
Milling, Drilling, Turning	1:20 (5.0%)	1:15 (6.7%)	1:25 (4.0%)	1:30 (3.3%)	—
Grinding	1:25 (4.0%)	1:20 (5.0%)	1:30 (3.3%)	1:30 (3.3%)	—
Shearing	—	—	—	—	1:200 (0.50%)
Edge Grinding	—	—	—	—	1:80 (1.25%)

CIMCOOL S2 is to be mixed with water for use. Add no other substances to the concentrate or mix unless approved by Cimcool Technical Services (513-841-8133).

RECOMMENDED CIMCOOL MIX MASTER PROPORTIONER TIP SIZES

Dilution	1:15 (6.7%)	1:20 (5.0%)	1:25 (4.0%)	1:30 (3.3%)	1:80 (1.25%)	1:200 (0.5%)
Tip Size	51	54	56	58	71	74

After installation of the tip, titrate the mix to be sure the concentration is correct. Leaner dilutions may be needed for makeup.

For concentration analysis, use the CIMCOOL "Mini" Kit, CIMCOOL Genetron Titration Procedure, or CTAC Titration Procedure for Lean Mixes.

TYPICAL PHYSICAL AND CHEMICAL PROPERTIES

Physical state	liquid
Appearance and odor	clear; burgundy
Colors available	pink, undyed
Solubility in water	100%
Weight, lb/gal, 60°F (15.6°C)	8.31
Specific gravity (H ₂ O = 1)	0.996
Boiling point, °F (°C)	212 (100)
Flash point, COC, °F (°C)	none; self-extinguishing
Fire point, COC, °F (°C)	none; self-extinguishing
Extinguishing media	no fire hazard
Unusual fire & explosion hazards	none
Freezing point (or pour point), °F (°C)	32 (0)
Protect from freezing	
pH, concentrate	10.2
pH, 1:20 (5.0%) mix, typical operating conditions	8.9
Total chlorine/chloride, wt %, calculated	none/0.004
Total sulfur, wt %, calculated	0.22
Diethanolnitrosamine, mercurials, phenols, PCB's, phosphates, PTBBA	none

PACKAGING

Available in 5-gallon pails, 55-gallon drums, Liqua Bins, and in tank truck and tank car quantities.

Do not reuse container before cleaning. After cleaning, remove label and relabel appropriately.

DOT LABELING REQUIREMENTS

Hazardous Materials Description and Proper Shipping Name (49 CFR 172.101):	Hazard Class (49 CFR 172.101):
Not a hazardous material	Not applicable

Product Safety Data

CIMCOOL S2

HEALTH HAZARD DATA

Not for internal consumption.

Emergency and First Aid Procedures:

- Skin— Avoid prolonged contact with concentrate. Flush with water.
Eyes— In case of contact with concentrate, flush with running water for 15 minutes. Call a physician.
Ingestion— If concentrate is swallowed, do not induce vomiting. Dilute with water or milk. Call a physician.
Inhalation— No first aid required; concentrate not volatile.

The following toxicity tests were conducted in accordance with the techniques specified in the Regulations for the Enforcement of the Federal Hazardous Substances Act (Revised, Federal Register, September, 1973).

- Acute Oral Toxicity (LD₅₀—Rats)— Above 5 g/kg (undiluted).
Acute Inhalation Toxicity (LC₅₀—Rats)— Above 20 mg/l for a 10% mix.
Acute Eye Irritation (Rabbits)— Negative (undiluted); no irritative or corrosive effects.
Primary Skin Irritation (Rabbits)— Negative (undiluted); noncorrosive and not a primary skin irritant.
Acute Dermal Toxicity (LD₅₀—Rabbits)— Above 2 g/kg (undiluted).
Bacterial Mutagenic Test (Ames)— Non-mutagenic.

REACTIVITY DATA

- Stability— Stable.
Hazardous polymerization— Will not occur.
Incompatibility (materials to avoid)— Avoid contact of concentrate with strong acids.
What volatile products are given off if subjected to open flame or abnormally high temperatures— Water vapor, carbon dioxide, and organic vapors.

SPILL OR LEAK PROCEDURES

- Steps to be taken if material is released or spilled— Flush with water.
Recommended disposal method(s)— Ultrafiltration, acid-alum-polymer chemical treatment, or high temperature incineration.

SPECIAL PROTECTION INFORMATION

- Respiratory Protection— None required.
Ventilation— No special requirements.
Protective Gloves— Not required.
Eye Protection— Safety goggles recommended when handling concentrate.
Other Protective Equipment— Normal metalworking plant protective equipment.

SPECIAL PRECAUTIONS

- Handling and Storage— None required.
Precautionary Labeling— See product label. Product labels for use in shop available to bulk users.

Minor formulation changes or normal variations in the manufacture of this product may cause slight variances in the data presented on this sheet.

CIMPLUS

RECOMMENDED STARTING DILUTIONS

Operation	Carbon Steels, Malleable Iron, Cast Iron	High Alloy Steels, Stainless Steels	Tool Steels, Drill Rod, Cast Steels
Grinding	1:100 (1.0%)	1:150 (0.7%)	1:100 (1.0%)
Machining	1:100 (1.0%)	—	—

Not recommended for grinding aluminum and copper alloys — may cause stain.

CIMPLUS is to be mixed with water for use. Add no other substances to the concentrate or mix unless approved by Cimcool Technical Services (513-841-8133).

RECOMMENDED CIMCOOL MIX MASTER PROPORTIONER TIP SIZES

Dilution	1:100 (1.0%)	1:120 (0.8%)	1:150 (0.7%)
Tip Size	60	64	66

After installation of the tip, titrate the mix to be sure the concentration is correct.

For concentration analysis, use the CIMPLUS Permanganate Titration Procedure.

Because the importance of rust control varies from job to job, the above dilutions may be made leaner where rust control is not a large problem, or can be made richer where rust control is difficult.

TYPICAL PHYSICAL AND CHEMICAL PROPERTIES

Physical state	liquid
Appearance and odor	clear; chemical
Colors available	undyed, green, pink*
Solubility in water	100%
Weight, lb/gal, 60°F (15.6°C)	10.14
Specific gravity (H ₂ O = 1)	1.216
Boiling point, °F (°C)	212 (100)
Flash point, COC, °F (°C)	none
Fire point, COC, °F (°C)	none
Extinguishing media	no fire hazard
Unusual fire & explosion hazards	none
Freezing point (or pour point), °F (°C)	-18 (-27.8)
If frozen, thaw completely at room temperature.	
pH, concentrate	10.6
pH, 1:100 (1.0%) mix, typical operating conditions	8.6
Total chlorine/chloride, wt %, calculated	none/0.0025
Total sulfur, wt %, calculated	0.18
Phenols, phosphates, mercurials, PCB's, mineral oil, PTBBA	none

PACKAGING

Available in 5-gallon pails, 55-gallon drums, Liqua Bins, and in tank truck and tank car quantities.

Do not reuse container before cleaning. After cleaning, remove label and relabel appropriately.

DOT LABELING REQUIREMENTS

Hazardous Materials Description and Proper Shipping Name (49 CFR 172.101):	Hazard Class (49 CFR 172.101):
Not a hazardous material	Not applicable

* Green and pink versions available in quantities of no less than 10 drums.

Product Safety Data

CIMPLUS

HEALTH HAZARD DATA

Not for internal consumption.

Emergency and First Aid Procedures:

- Skin— Avoid prolonged contact with concentrate. Flush with water.
Eyes— In case of contact with concentrate, flush with running water for 15 minutes. Call a physician.
Ingestion— If concentrate is swallowed, do not induce vomiting. Dilute with water or milk. Call a physician.
Inhalation— No first aid required; concentrate not volatile.

The following toxicity tests were conducted in accordance with the techniques specified in the Regulations for the Enforcement of the Federal Hazardous Substances Act (Revised, Federal Register, September, 1973).

- Acute Oral Toxicity (LD₅₀—Rats)— Above 5 g/kg for a 2% mix.
Acute Inhalation Toxicity (LC₅₀—Rats)— Above 20 mg/l for a 2% mix.
Acute Eye Irritation (Rabbits)— Negative for a 2% mix; no irritative or corrosive effects.
Primary Skin Irritation (Rabbits)— Negative for a 2% mix; noncorrosive and not a primary skin irritant.

REACTIVITY DATA

- Stability— Stable.
Hazardous polymerization— Will not occur.
Incompatibility (materials to avoid)— Avoid contact of concentrate with strong acids
What volatile products are given off if subjected to open flame or abnormally high temperatures— Water vapor, carbon dioxide, and organic vapors.

SPILL OR LEAK PROCEDURES

- Steps to be taken if material is released or spilled— Flush with water.
Recommended disposal method(s)— Ultrafiltration, acid-alum-polymer chemical treatment, or high temperature incineration.

SPECIAL PROTECTION INFORMATION

- Respiratory Protection— None required.
Ventilation— No special requirements.
Protective Gloves— Not required.
Eye Protection— Safety goggles recommended when handling concentrate.
Other Protective Equipment— Normal metalworking plant protective equipment.

SPECIAL PRECAUTIONS

- Handling and Storage— None required.
Precautionary Labeling— See product label. Product labels for use in shop available to bulk users.

Minor formulation changes or normal variations in the manufacture of this product may cause slight variances in the data presented on this sheet.

21-2M-A

PC-899 (replaces PC-482-B and PC-540-2)

Products Division | Cincinnati Milacron Marketing Company
Cincinnati, Ohio 45209

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